

303 R.625

Work Order ID 92972

November-12-12 3:31:20 PM

92972

Page 1

Item ID: 647.9110

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Thrusert

Start Date: 12/11/2012 Start Qty: 260.00

260

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 260.00

260

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-11-13 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

647.8900

.9100

Rev N/C

Jal 12.11.14

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA & DWG ,FOLIO REV: N/ADWG REV: N/C

2-DEBURR AS REQUIRED

12/12/17

260

0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12/12/17

260

0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 92972

November-12-12 3:31:20 PM

92972

Page 2

Item ID: 647.9110

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Thrusert

Start Date: 12/11/2012 Start Qty: 260.00

260

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 260.00

260

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
13
9-83

12/12/18 (260) ϕ

130

Identify as per dwg & Stock Location **ST 440** 0.00

130

Packaging

Memo

0.00

Packaging

IDENTIFY WITH PERMANENT INK MARKER

2600X

SD
12-12-18

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/12/18 ϕ
ML5 12-12-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

November-12-12 3:31:23 PM

Page 1

Work Order ID: 92972

92972

Parent Item: 647.9110

647 9110

Parent Item Name: Thrusert

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 260.00

Required Qty: 260.00

Comments: IPP REV:A NEW ISSUE 12-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No				f	217.7982		10.94737			
									**	13.333		12/12/12	

M303R0 625

303 Round Bar 0.625"

Location

Loc Qty

Loc Code

MAT028

217.79821

118400

2

119009

59.79821

119766

156

13.333

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTIC. NO. 03294				SHEET 1 OF 1	
	DWG NO. 647.9100	REV: N/C	PREPARED BY A. QUAN	DATE: 12/07/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: THRUSERTS					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED MATERIAL DUE TO AVAILABILITY ISSUES				

SHEET 1, NOTES IS:

NOTES

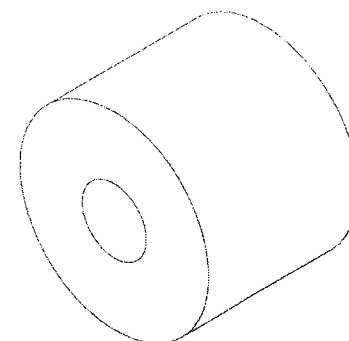
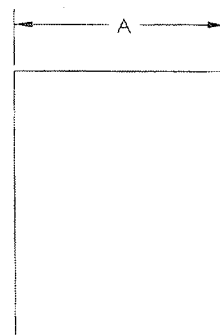
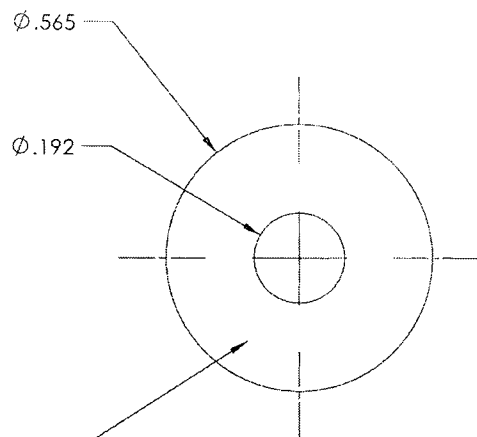
1. MATERIAL 303 SS IAW AMS 5640.
2. FINISH NONE
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12 PT CENTURY GOTHIC.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 92972 MJS
12-11-13

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						
				CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

NOTES:

1. MATERIAL: 303 SS IAW AMS 5643, 1/4H.
2. FINISH: NONE.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12 PT. CENTURY GOTHIC.



647.911X

P/N	LENGTH (A)
647.9110	.450
647.9111	.535
647.9112	.140
647.9113	.300
647.9114	.545

UNINCORPORATED ECN(s)

03294

QTY		PARTS LIST	
NEXT ASSY (S)	ORIGINAL DATE	APICAL INDUSTRIES	
	647.8900		
DRAWING BY	DESIGNED BY	2608 TEMPLE HEIGHTS DR.	
	647.8900		
DRAWING APPROVAL	DESIGNED BY	OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	647.8900		
CONTRACTING	DESIGNED BY	THRUSERT	
	647.8900		
UNLESS OTHERWISE SPECIFIED	DESIGNED BY	SCALE NONE	
	647.8900		
DIMENSIONS ARE IN INCHES	DESIGNED BY	SHEET 1 OF 1	
	647.8900		
TOLERANCES ARE:	DESIGNED BY	REV. N/C	
	647.8900		
2 PLACE DECIMALS ±.010	DESIGNED BY	647.9100	
	647.8900		
3 PLACE DECIMALS ±.003	DESIGNED BY	647.9100	
	647.8900		
ANGLES ±.5°	DESIGNED BY	647.9100	
	647.8900		

